

Date: Monday, 05/02/2007 9:44:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 BEARPAW
Job Number : 30634	
Estimate Number : 12480	
P.O. Number : N/A	Part Number : D35291
This Issue : 05/02/2007 S.O. No. : N/A	Drawing Number : D3529 PRELIMINARY
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : PREL
Previous Run : 30311	Material : N/A
Written By : <i>[Signature]</i> 07-02-05	Due Date : 09/02/2007 Qty: 3 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-06-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.2796 sf(s)/Unit Total : 3.8389 sf(s)

Pick:

blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"(MUHMWB10)

Batch: 103315 / 3PCS

101254 / 1PCS

(4)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

J.L./J.F. 07/02/06 (3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L./J.F. 07/02/06 (3)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 07-02-07

Engineering Approval - Project Manager

CB

07.02.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 12 Date: 06/27/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/02/2007 9:44:53 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 30634

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A. *ls.*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ls. 07.02.07

Job Completion



PART WENT TO HAI. PART NOT APPROVED AND NOT AIRWORTHY
CB 07.07.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

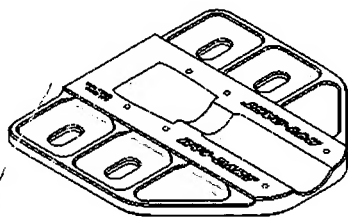
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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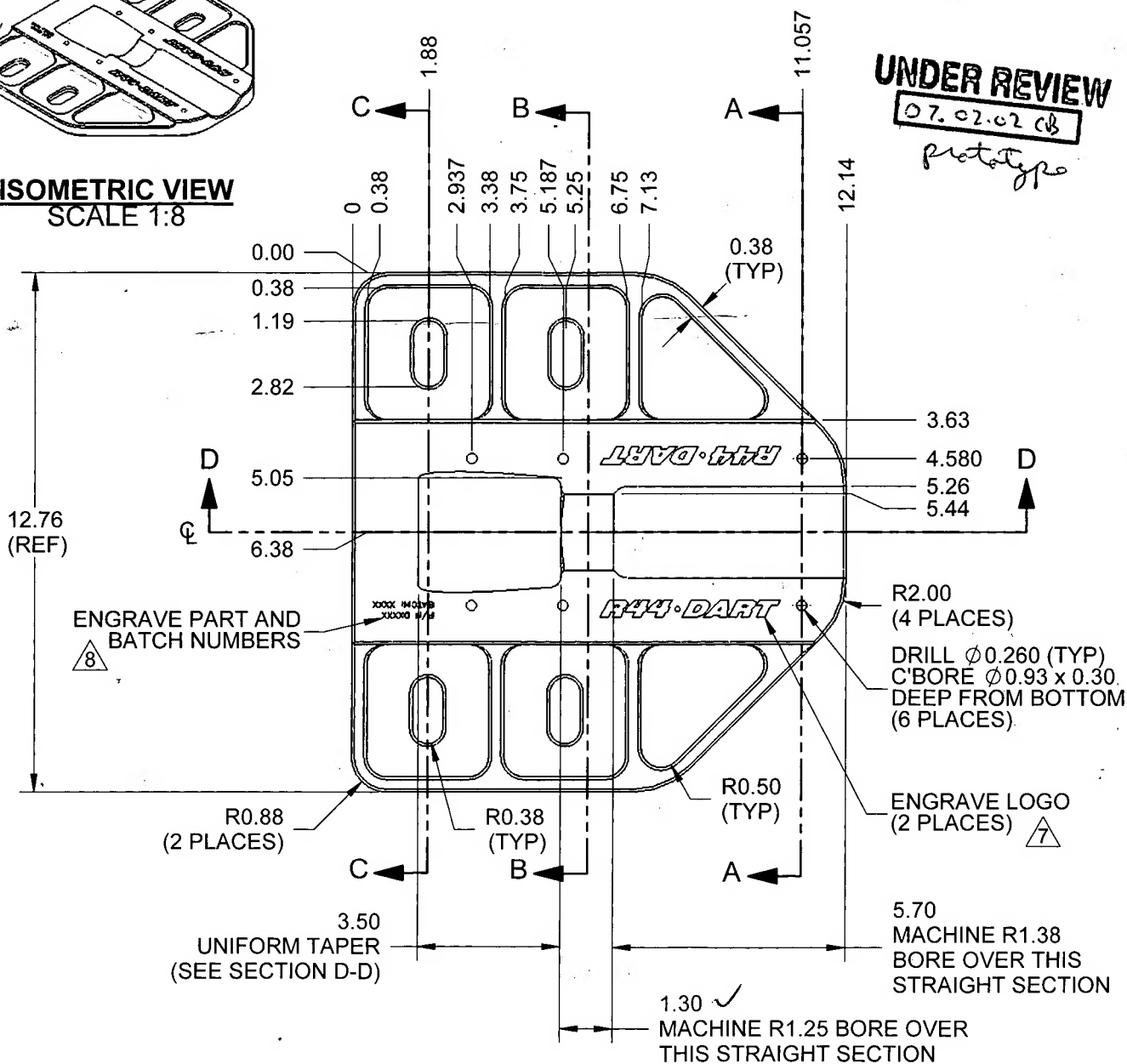
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04	TITLE R44 BEARPAW		SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



UNDER REVIEW
07.02.02 CB
prototype

D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT \varnothing
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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1-2-80

PAID BY BANK



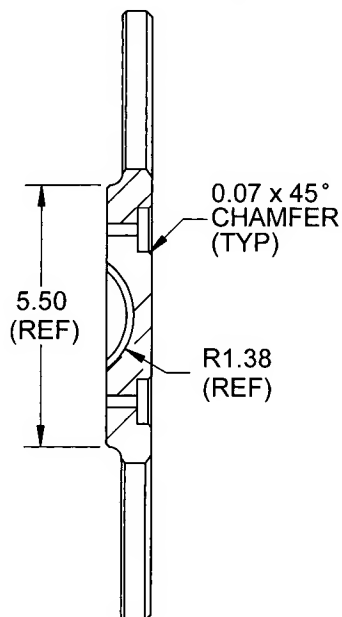
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

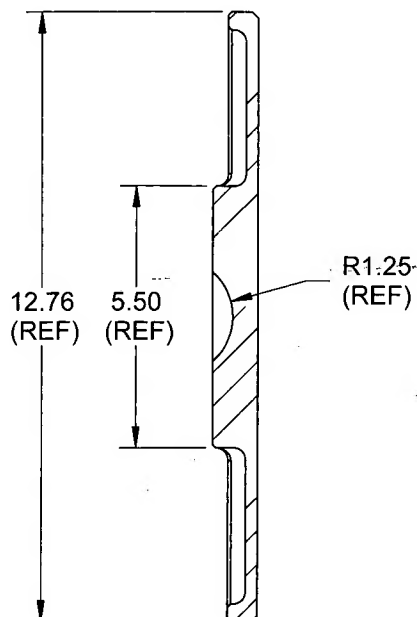
UNDER REVIEW

07.02.02 CB

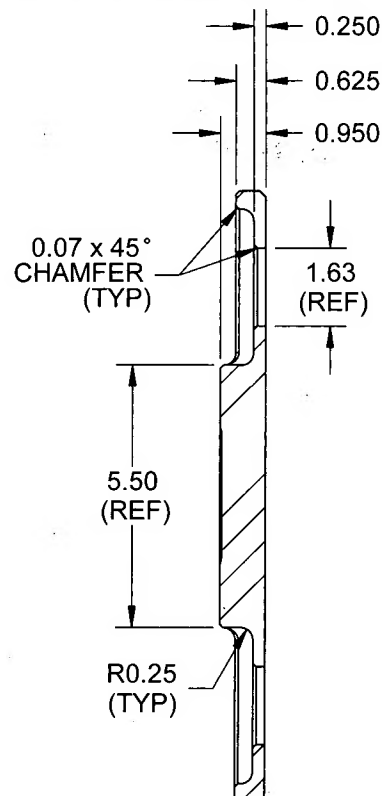
prototype



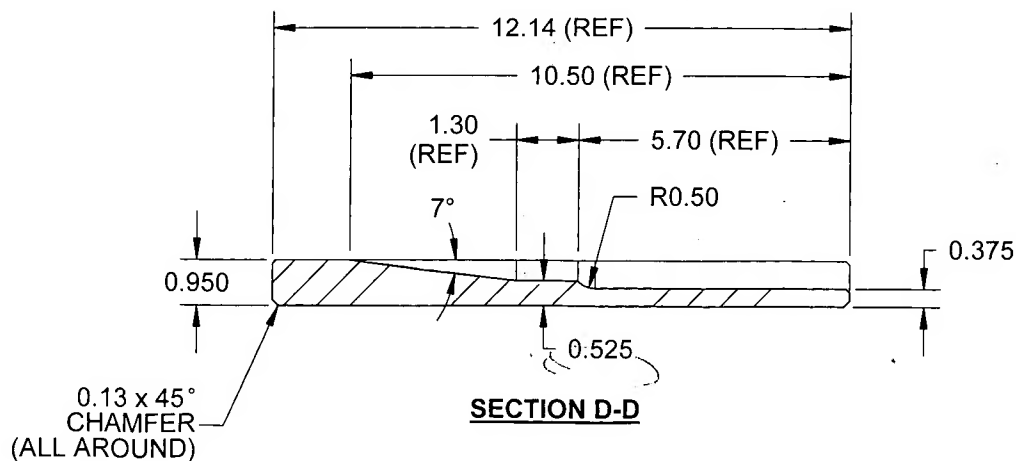
SECTION A-A



SECTION B-B



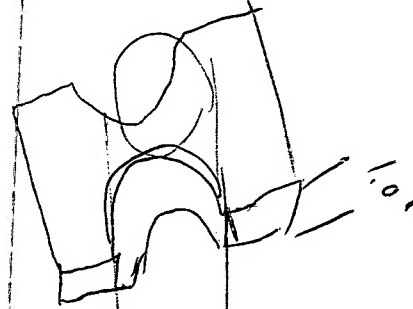
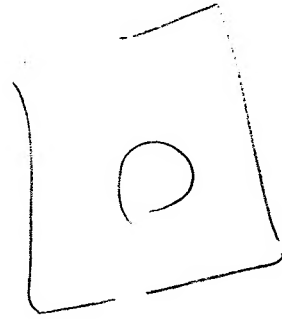
SECTION C-C



SECTION D-D

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101372

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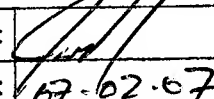
DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

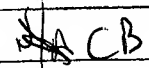
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.38"	±.030"	.38"	✓			
1.19"	±.030"	1.190"	✓			
5.05"	±.030"	5.05"	✓			
3.50"	±.030"	3.50"	✓			
12.76"	±.030"	12.76"	✓			
1.30"	±.030"	1.30"	✓			
5.70"	±.030"	5.70"	✓			
Ø.260"	+1.000" -1.001"	Ø.259"	✓			
Ø.930"	+1.000" -1.001"	.935"	✓			
.300 deep	±.030"	.305"	✓			
4.580"	±.010"	4.579"	✓			
2.937"	±.010"	2.945"	✓			
5.50"	±.030"	5.502"	✓			
.070 X 45°	±.030"	.095"	✓			
1.63"	±.030"	1.618"	✓			
1.250"	±.010"	1.255"	✓			
.625"	±.010"	.629"	✓			
.950"	±.010"	.954"	✓			
12.140"	±.030"	12.140"	✓			
.525"	±.010"	.524"	✓			
.375"	±.010"	.377"	✓			
.13" X 45°	±.030"	.130" X 45°	✓			

Measured by:	J.F.
Date:	07/02/06

Audited by:	
Date:	07-02-07

Prototype Approval:	
Date:	07.02.07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date
Jan 25, 2007

Page
1

Receipt Number
RCP00003589

Purchase From:

G E Polymershapes
9150 Airport Road
Brampton, ON L6S 6G1
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-GEP001	PO00002894

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	MUHMWB10	UHMW 1" Black 90- 19.50 X 24 34- 16.00 X 10.50 14- 13.25 X 24.25 40- 19.50 X 48 CUT TO SIZES AS FOLLOWS: BE ACCEPTED. STRAPPING WITH CARDBOARDS. SCRATCHES WILL NOT PACKAGING: MATERIAL MUST BE PROTECTED FROM 1" GUARANTEED - TOLERANCE - 0.030/NO MINUS MANUFACTURER: POLY HI SOLDUR UHMW BLACK TIVAR 1000 VIRGIN MATERIAL NOTE: 17 SHEETS 4 FT X 10 FT X 1" BLACK UHMW B/N103315	680.0000	sf	19.125000	13,005.00	Jan 25, 2007

Comments:



GE Polymershapes

1250 OLD INNES RD. UNIT 519 OTTAWA ONT. K1B 5L3

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE LTD

DATE: January 18, 2007

YOUR PURCHASE ORDER: 2894

OUR SHIPPER NO: 075632

LINE ITEM #: 001

QUANTITY: 17

DESCRIPTION: BLACK U.H.M.W. 1.00" X 48" X 120"

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:
MIL-STD-P-23336, TYPE II, CLASS B GRADE 5
MIL-21922, TYPE 1 CLASS M, GRADE 2, CAT 5
MIL-17901, CLASS III, CAT 5

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

SALES REPRESENTATIVE SIGNATURE

ALEXANDRA DAY
CUSTOMER SERVICE REPRESENTATIVE